

1. A method of manufacturing a cover for a bedding product, said method comprising:
 - forming a welt cord;
 - securing said welt cord to a side panel of said bedding product; and
 - 5 securing non-skid decking to the combined welt cord and side panel, the welt cord being sandwiched between the side panel and non-skid decking.
2. The method of claim 1 wherein said side panel is gathered at select locations prior to securing said welt cord to said side panel.
3. The method of claim 1 wherein said welt cord is made by sewing material around a filler cord.
4. The method of claim 1 wherein said welt cord and said side panel are sewn together.
5. The method of claim 1 wherein said non-skid decking is sewn to said combined side panel and welt cord.

6. A method of manufacturing a cover for a bedding product, said method comprising:

forming a welt cord;

sewing said welt cord to a web of border material to form a web of welted

5 border;

cutting said web of welted border to a specified length;

securing opposite ends of said specified length of welted border together to form a loop; and

sewing non-skid decking to the loop of welted border, the welt cord being

10 sandwiched between the border material and non-skid decking.

7. The method of claim 6 wherein said web of border material is gathered at select locations prior to sewing said welt cord to said web of border material.

8. A method of manufacturing a cover for a bedding product, said method comprising:

- forming a welt cord by wrapping material around a cord;
- placing said welt cord above a web of border material;
- 5 sewing said welt cord to said web of border material;
- cutting said welt cord and said web of border material to a predetermined length;
- securing opposite ends of said border material to each other to form a loop; and
- sewing non-skid decking to the loop of border material, the welt cord being sandwiched between the border material and non-skid decking.

9. The method of claim 8 wherein said web of border material is gathered at select locations prior to sewing said welt cord to said web of border material.

10. The method of claim 8 wherein said welt cord is sewn to said web of border material at a first sewing machine and said non-skid decking is sewn to said loop of border material at a second sewing machine.

11. The method of claim 10 wherein said cutting occurs at said first sewing machine.

12. A method of manufacturing a cover for a bedding product, said method comprising:

forming a continuous welt cord;

placing said continuous welt cord above a web of border material;

5 feeding said continuous welt cord and said web of border material to a sewing machine, said sewing machine having a needle, a presser foot secured to a presser foot shaft, a variable speed puller and a controller to control the stitch rate of said sewing machine and the speed of rotation of said puller,

moving said web of border material with a feed dog of said sewing machine at a
10 predetermined speed, said web of border material passing underneath a lower plate of said presser foot and said continuous welt cord passing between an upper plate and said lower plate of said presser foot;

sewing said continuous welt cord to said web of border material, said needle passing through said upper plate of said presser foot to create a border assembly;

15 pulling said border assembly with said puller.

13. The method of claim 12 further comprising cutting said border assembly to a predetermined length and securing opposite ends of said border assembly together.

14. The method of claim 13 further comprising securing non-skid decking to the border assembly, the welt cord being sandwiched between the border material and non-skid decking.

15. The method of claim 12 further comprising intermittently slowing the speed of rotation of said puller while maintaining said speed of said feed dog to gather said web of border material at select locations.

16. A method of manufacturing a cover for a bedding product, said method comprising:

- forming a continuous welt cord;
- placing said continuous welt cord above a web of border material;
- 5 moving said web of border material with a feed dog of a sewing machine along a supporting surface, said web of border material passing underneath a lower plate of a presser foot secured to a presser foot shaft of said sewing machine and said continuous welt cord passing between an upper plate and said lower plate of said presser foot;
- sewing said continuous welt cord to said web of border material with a needle
- 10 passing through said upper plate of said presser foot to create a border assembly;
- pulling said border assembly with a puller located behind said presser foot;
- intermittently slowing the speed of rotation of said puller while maintaining said speed of said feed dog of said sewing machine to gather said web of border material at select locations;
- 15 cutting said border assembly to a predetermined length.

17. The method of claim 16 further comprising securing non-skid decking to the border assembly, the welt cord being sandwiched between the side panel and non-skid decking.

18. A method of manufacturing a bedding foundation, said method comprising:

- securing a spring assembly to a base;
- manufacturing a cover for the bedding foundation by constructing a welt cord;
- 5 securing a side panel to the welt cord,
- securing non-skid decking to the combined welt cord and side panel, the welt cord being sandwiched between the side panel and non-skid decking;
- separating the side panel and non-skid decking so as to expose the welt cord; and
- wrapping the cover around the spring assembly and base such that the welt cord
- 10 extends upwardly and is spaced inwardly from the perimeter of the bedding foundation;
- and
- securing the cover to the base.

19. The method of claim 18 wherein said welt cord is made by sewing border material around a filler cord.

20. The method of claim 18 wherein said side panel is sewn to said welt cord.

21. The method of claim 18 wherein said non-skid decking is sewn to said combined welt cord and side panel.

22. The method of claim 18 wherein said side panel is gathered at select locations prior to securing said welt cord to said side panel.

23. A bedding foundation comprising:
- a base;
 - a spring assembly secured to the base;
 - a cover surrounding the spring assembly and secured to the base;
- 5 a welt cord secured to the cover and spaced inwardly from an upper perimeter of the foundation, said welt cord extending upwardly from the cover; and
- non-skid decking integrally formed in the cover inside the welt cord.

24. A sewing machine for sewing a welt cord to a web of border material, said machine comprising:

a base adapted to support said web of border material;

a folder for creating a welt cord;

5 a needle;

a motor operably connected to the needle and operable to reciprocate the needle; and

a presser foot secured to a presser foot shaft, said presser foot having a lower plate adapted to hold material against said base and an upper plate having a hole
10 through which said needle passes when reciprocated.

25. The sewing machine of claim 24 further comprising a feed dog extending upwardly through an opening in said base for moving said web of border material.

26. The sewing machine of claim 24 further comprising a variable speed puller for pulling said web of border material past said needle and presser foot.

27. The sewing machine of claim 26 wherein said variable speed puller comprises two wheels.

28. The sewing machine of claim 26 further comprising a controller for controlling the speed of said variable speed puller.

29. The sewing machine of claim 24 further comprising a controller for controlling the stitch rate of said machine.